

We claim:

1. A method for rewinding a thread group on a cone-type warping machine from a warping drum mounted in a warping stand onto a warp beam mounted in a beaming stand, at the same time maintaining a tension in the thread group by braking the warping drum, the warping stand and the beaming stand being displaced axially parallel in relation to one another during rewinding, said method comprising a step of supporting the warping stand and the beaming stand directly or indirectly relative to one another in order to compensate for the tension in the thread group.
2. The method as claimed in claim 1, wherein the warping stand is displaced on rails in relation to the fixed beaming stand, and wherein the support is disposed approximately at or above the horizontal plane of the warping drum axis.
3. The method as claimed in claim 1, wherein the support takes place via a force measurement device which generates a measurement signal corresponding to the tensile force in the thread group
4. The method as claimed in claim 3, wherein the braking force at the warping drum is regulated with the aid of the measurement signal.
5. The method as claimed in claim 1, wherein rewinding takes place from the vertex line of the warping drum to the vertex line of the warp beam.
6. The method as claimed in claim 5, wherein the rewinding is performed without a deflecting roller.
7. The method as claimed in claim 1, wherein the warping drum is braked by means of at least four brake disks, each of which is equipped with at least two brake grippers, and wherein the brake grippers are activated or deactivated sequentially in succession as a function of the necessary braking capacity.

8. An apparatus for rewinding a thread group on a cone-type warping machine from a warping drum mounted in a warping stand onto a warp beam mounted in a beaming stand, at the same maintaining a tension by the braking of the warping drum by means of a braking device, the warping stand and the beaming stand being mounted so as to be displaceable axially parallel in relation to one another, wherein the warping stand and the beaming stand are supported directly or indirectly relative to one another in order to compensate for tensile forces acting in the thread group.
9. The apparatus as claimed in claim 8, wherein the support takes place at at least two supporting bearings.
10. The apparatus as claimed in claim 9, wherein the distance between the at least two supporting bearings is equal to or greater than the maximum useful width (cylindrical portion plus conical portion) of the warping drum.
11. The apparatus as claimed in claim 9, wherein at least one of the supporting bearings is provided with a force measurement device for measuring the tensile force in the thread group which corresponds to a defined pressure force
12. The apparatus as claimed in claim 11, wherein the force measurement device is operatively connected to the braking device at the warping drum in order to regulate the tensile force in the thread group.
13. The apparatus as claimed in claim 8, wherein the warping drum stand is mounted on rails, and wherein the support takes place approximately at or above the horizontal plane of the warping drum axis.
14. The apparatus as claimed in claim 8, wherein the support is provided with an emergency stop device for interrupting the relative displacement between the warping stand and the beaming stand when a resistance force is exceeded.

15. The apparatus as claimed in claim 8, wherein the support takes place at at least two supporting bearings which are designed as barriers for shutting off the interspace between the beaming stand and the warping stand.
16. The apparatus as claimed in claim 8, wherein the braking device at the warping drum has at least four brake disks, each of which is provided with at least two brake grippers.
17. The apparatus as claimed in claim 16, wherein two brake disks are arranged in each case on each side of the warping drum, and wherein the outer brake disks in each case are fastened on the warping drum axis so as to be releasable from outside.
18. The apparatus as claimed in claim 16, wherein the brake grippers on each brake disk are located diametrically opposite to one another, and wherein the pairs of brake grippers of adjacent brake disks are arranged so as to be offset angularly to one another.